

Date: Friday, 10/5/2007 11:02:10 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 35045	
Estimate Number : 10950	
P.O. Number : <i>N/A</i>	Part Number : D2562005
This Issue : 10/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2562 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>MA</i>	Drawing Revision : D
Previous Run : 32575	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/19/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 10 Um: Each
Comment : Est A 02.06.07 New Issue NG	

## Additional Product

Job Number:



Seq. #:	Machining Or Operation:	Description :
---------	-------------------------	---------------

1.0	M304TR0500W035	304 RD Tube .500 x .035W
-----	----------------	--------------------------



Comment: Qty.: 2.5374 f(s)/Unit Total : 25.3743 f(s)  
304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall  
Batch *M 105 575 (7)* *M 104 862 (3)* *SB 07/10/16 (10)*

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Punch to length as per Dwg D2562

*SB 07/10/16 (10)*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL/MED FAB RESOURCE

1- Bend end as per Dwg D2562 Angle "D"  
2- Deburr

*[Signature]* *07/10/17* *PTO (9)*

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

*-5 07/10/17 (42) center*

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING





Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*M 105 068* *(9X)* *m-l 07/10/18*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del>07/01/17</del>	3						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/10/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/17	3	1 piece hole was damage in the punch operation RE: operator error		Scrap + destroy no Replace	SP 07/10/17	 07/10/17		 07/10/17

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 11:02:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35045

Part Number: D2562005

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*8/7/10/18 (9)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57064*

*8/7/10/18 (9)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*8/7/10/18 (9)*

Job Completion



*IN 8/10/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

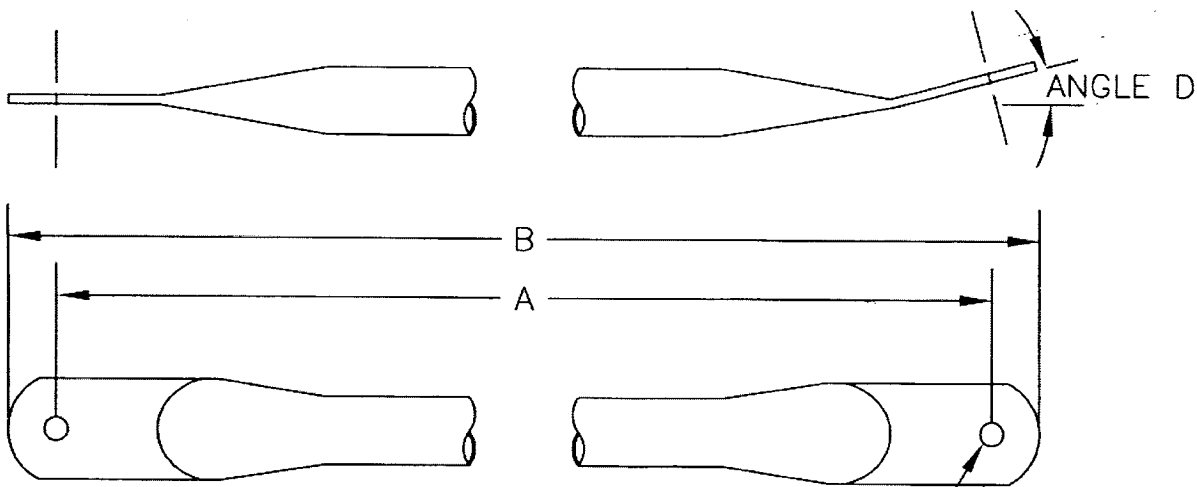
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.05.18	DRAWING NO.	D2562	REV. D
		TITLE	STRUT	SHEET 1 OF 1
				SCALE
A	96.05.01	NEW ISSUE		1:2
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)		
C	02.06.05	ADD -005; ADD FINISH		
D	05.05.18	ADD -007/-011/-013; UPDATE -005		



"C" DIA TO BE OPENED MANUALLY  
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35045

**GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.21

Copyright © 1996 by DART AEROSPACE LTD

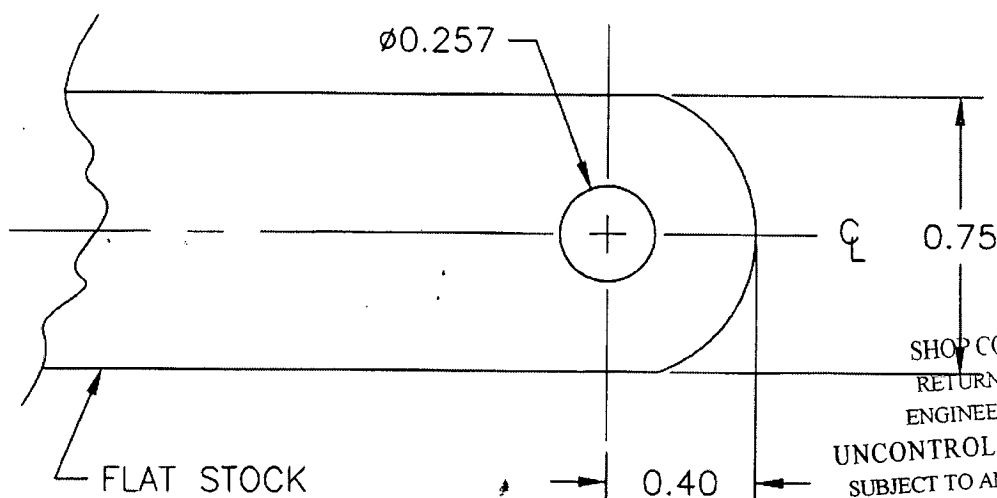
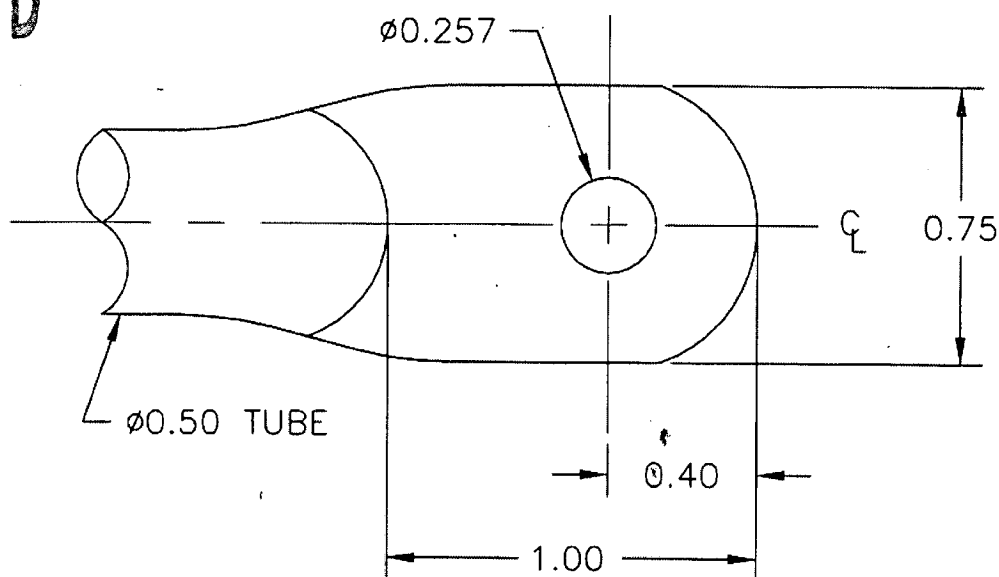
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED my	APPROVED JA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24	TITLE PUNCH DT8012 SPEC CONTROL		SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#CP 01.12.20	ADD TOLERANCE NOTE	

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED  
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35045

## CUSTOMER RETURN

#R08-51

Initiator: Jean Kerr  
 Company: Rotocraft Support  
 Phone No: 818-997-7667

Date: May 9/08

Invoice # 16386  
 Order Entry # 5931

Reason for return: too long. purchased the incorrect strut. Attach Copy of DHS Return Authorization # 414

Receiving: 8/0/06  
 Date Received: 8/0/06 Freight Company: FIDEX Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D2562-005	35045	Strut	<u>DATE</u>	<u>5/20</u>

Condition of packaging: Good Photograph required: yes ☒ no ☐

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☒

QC: Quarantine: Location:   Condition of Part: good

Inspect: Initial:  

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D2562-005	35045	return to stock per W/O	<u> </u>	<u>39500</u>	

## QA Coordinator:

Advise GM as to findings: Initial:   Date:  

Comments:

Issue credit: yes no

GM Approval:   Date:  

Invoice Amount:    
 Less Replacement:    
 Restock Fee:    
 Freight:    
 Net Credit:    
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed:   Date:  

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit